

Work Order ID 82261

82261

Page 1

March-27-12 2:44:22 PM

Item ID: D2857-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Hinge Bracket

Stop ***NS2***

Start Date: 27/03/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 10/04/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2857 | Rev C |

| | | | | | | | | | |
|----------------|-------------------|------|----|----------|--|----|--|--|--|
| 100 | BAND SAW | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Bandsaw | Memo | 0.00 | | | | | | | |
| Jeaspa Bandsaw | Cut blanks 4.425" | | PO | 12/04/07 | | 24 | | | |

| | | | | | | | | | |
|------------------------------|--|------|----|----------|--|--|--|--|--|
| 110 | HAAS CNC VERTICAL MACHINING #1 | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | 1-Machine per folio FA940 FOLIO REV: <u>AA</u> DWG REV: <u>C</u> 2-Deburr any rough edges | | SL | 12/04/10 | | | | | |

| | | | | | | | | | |
|-----------------|---|------|----|----------|--|----|--|--|--|
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | SL | 12/04/10 | | 24 | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 82261

82261

Page 2

March-27-12 2:44:22 PM

Item ID: D2857-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 27/03/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 10/04/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|-------------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | mk 12/04/11 | | 24 | | | |
| 140 *140* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 24 | | 12-4-11 | |
| 160 *160* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:45 OVEN TEMPERATURE: 320°F FINISH TIME: 4:15 | 0.00 0.00 | | | | 24 X | | mk 12/04/12 | |

M120222

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Picklist Print

March-27-12 2:44:26 PM

Page 1

Work Order ID: 82261

82261

Parent Item: D2857-1

D2857-1

Parent Item Name: Hinge Bracket

Start Date: 27/03/2012

Required Date: 10/04/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C00.06.22Removed P/O for powder coatEC
IPP D06.05.01Added level 8 EC IPP Rev:E
10.06.10 remove seq150 DD verf:JLM IPP Rev:F 11.01.06 as
per dwg revC DD verf:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B2.000X01.25 0 | | Purchased | No | | | 100 | f | 28.9433 | 0.37 | 9.347368 | | | |

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

**

PO 12/04/07

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT009 | 16.94326358 | |
| 114899 | 4.15263158 | |
| 116623 | 2.15 | |
| → 119136 | 10.640632 | |
| MAT010 | 12 | |
| 121040 | 12 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|-----------------------------------|----------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 82261 |
| Description: Hinge Bracket | | Part Number: D2857-1 |
| Inspection Dwg: D2857 | Rev: Bc | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 4.300 | +/-0.010 | 4.300 | ✓ | | Vern | SL-1 |
| 4.000 | +/-0.010 | 4.001 | ✓ | | HG | |
| 0.340 | +/-0.010 | .34 | ✓ | | Vern | SL-1 |
| 1.110 | +/-0.005 | 1.110 | ✓ | | " | |
| 1.790 | +/-0.010 | 1.791 | ✓ | | " | |
| 1.320 | +/-0.005 | 1.320 | ✓ | | " | |
| 2.000 | +/-0.010 | 2.002 | ✓ | | " | |
| 0.340 | +/-0.010 | .340 | ✓ | | " | |
| 0.447 | +/-0.010 | .446 | ✓ | | HG | |
| Ø0.171 | +0.005/-0.000 | .173 | ✓ | | Vern | SL-1 |
| 0.147 | +/-0.010 | .143 | ✓ | | " | |
| 0.376 | +/-0.010 | .379 | ✓ | | " | |
| 0.126 | +/-0.010 | .125 | ✓ | | " | |
| 0.063 | +/-0.010 | .062 | ✓ | | " | |
| Ø0.166 | +0.005/-0.000 | .166 | ✓ | | " | |
| 0.911 | +/-0.010 | .910 | ✓ | | HG | |
| 0.600 | +/-0.010 | .600 | ✓ | | Vern | SL-1 |
| 0.125 | +/-0.010 | .130 | ✓ | | " | |
| 0.150 | +/-0.010 | .148 | ✓ | | " | |

| | | | |
|------------------------|--------------------------------|----------------------------|-----|
| Measured by: Sh | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 12/04/10 | Date: 12/04/11 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------|------------|-------------|
| A | 04.06.15 | New Issue | KJ/JLM | |
| B | 07.04.20 | Dimensions update per Dwg Rev B | KJ/JLM | [Signature] |

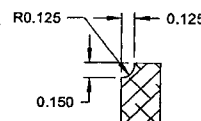
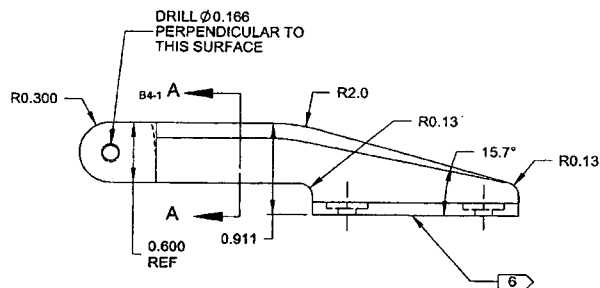
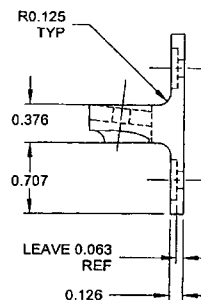
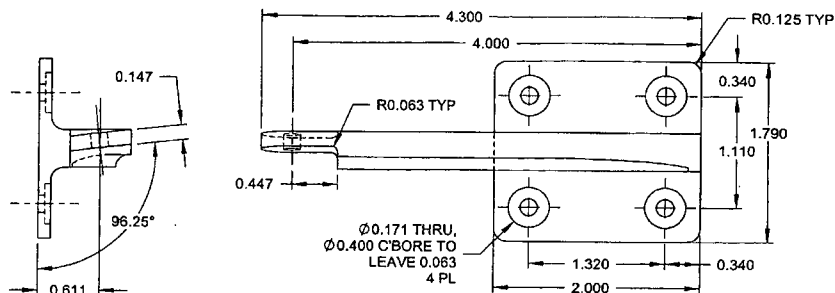
Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



SECTION A-A

D2857-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82261 MLJ
12/03/27

RELEASED
2010-11-26

| | | | |
|------------|---|--|----------|
| C | REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040 | CP | 10.09.13 |
| B | ADD THICKNESS, REDRAW W/ SOLIDWORKS | LE | 06.08.28 |
| A | NEW ISSUE | KE | 08.12.14 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2857 SHEET 1 OF 2 TITLE HINGE BRACKET SCALE NTS DATE 10.09.13 <small>COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |
| DRAWN | gp | | |
| CHECKED | gp | | |
| MFG. APPR. | gp | | |
| APPROVED | gp | | |
| DE APPR. | gp | | |
| DATE | 10.09.13 | | |

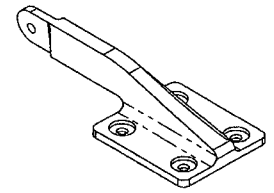
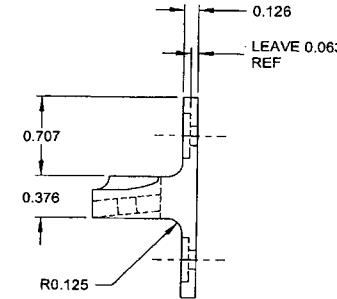
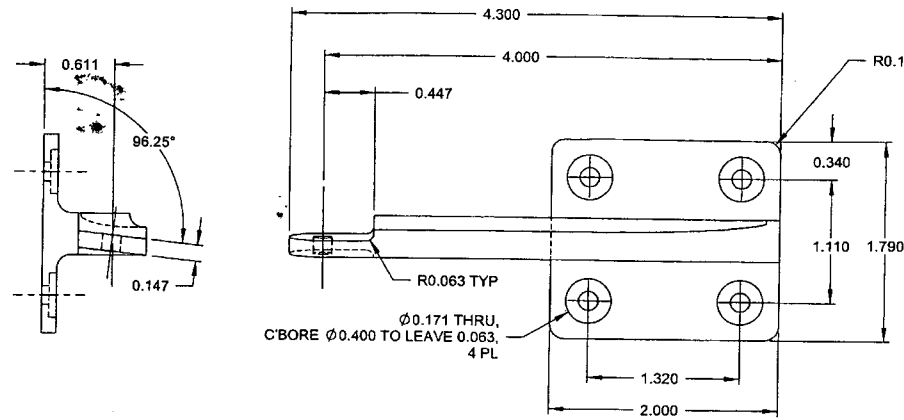
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

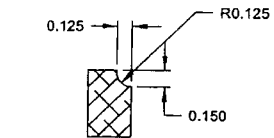
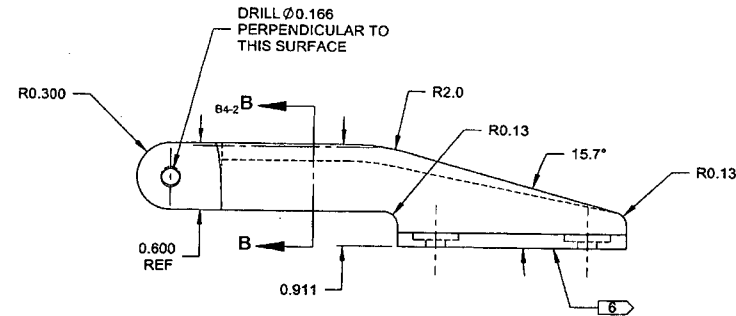
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



82261



B7-2 SECTION B-B

D2857-2 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6081T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-2" PER DART QSI 044 6.1(FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | KE | DART AEROSPACE LTD | |
| DRAWN | 91 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D2857 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HINGE BRACKET | NTS |
| DATE | 10.09.13 | COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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